

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020053**Date Inspected:** 24-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng Wei			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12BE, Deck Pannel Diaphragms, PP113.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector ZPMC Personnel performing fit up of Deck Pannel Diaphragms at DP3016-PP114.5. The attached photographs provide additional detail.

Assembly, Bay 14, 12AW, Deck plate (DP3040A) to Deck plate (DP3041A).

FCAW welding of weld joint SEG3004*-008/026; located on assembly, Bay 14, 12AW. Welder is identified as 204730; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12AE, SEG3001.

SMAW welding of weld joint SP3002C-177, 179, 181, 185, 187, 189; located on assembly, Bay 14, 11AE. Welder is identified as 200113; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

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Assembly, Bay 14, Traveler rail.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel performing Ultrasonic testing (UT) on Traveler rail identified as 11TR002-005. The attached photographs provide additional detail.

Assembly, Bay 14, 12BE, Corner Assembly CA3002C.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector ZPMC Personnel performing fit up of Edge plate identified as EP3002A. The attached photographs provide additional detail.

Assembly, Bay 14, 12CE, CA3004.

FCAW welding of weld joint CA3004E-001, 002, 011, 012, 201, 202, 211, 212; located on assembly, Bay 14, 12CE. Welder is identified as 044801; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4133.

Assembly, Bay 14, 12CE, CA3004, Deck plate to Edge plate.

FCAW welding of weld joint CA3004-004; located on assembly, Bay 14, 12CE. Welder is identified as 055491, 044801; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed following things

- BP3032-004 welding in process.
- BP3032-005 welding in process.
- BP3032-006 tack welding in process.
- ZPMC started tacking bottom plate BP3032-006 from middle of the joint towards ends of the weld joint.

Subassembly, Bay 03, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed following things,

- FB4125 & FB3109 welding in process.

Training for Phased Array Ultrasonic Testing.

This QA inspector attended Training for Phased Array Ultrasonic Testing (PAUT) from 1600Hrs. to 1900Hrs.

This QA Inspector carried out NDE on following

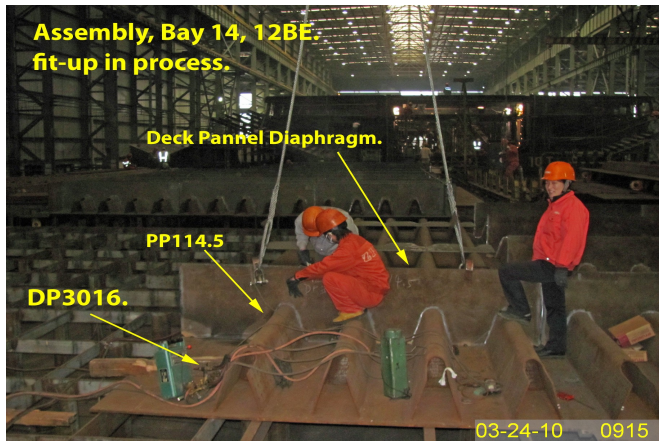
Blast shop 01, 9AW.

This QA inspector performs Random Visual Testing (VT) after blast; of area previously tested and accepted by ZPMC Quality Control personnel of 9AW (exterior). Indications found were documented & marked for further processing.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
